

Date: Thursday, 05/02/2009 3:47:51 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PLATE
 Job Number : 45580
 Estimate Number : 13739
 P.O. Number :
 This Issue : 05/02/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D38663
 Drawing Number : D3866 PRELIM Rev. A
 Project Number : N/A
 Drawing Revision : PRELIM Rev. A
 First Issue : / / Type : SMALL / MED FAB
 Drawing Revision : PRELIM
 Previous Run : 44954 Material :
 Due Date : 20/02/2009 Qty: 6 Um: Each
 Written By :
 Checked & Approved By : JUD 09.02.04
 Comment : Est Rev:A 09-01-19 as per prelim issue DD verified by:ec

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 6061-T6 .125 Sheet 6061-T6 .125 Sheet



Comment: Qty.: 0.1061 sf(s)/Unit Total: 0.6363 sf(s)

6061-T6 .125 Sheet

batch: 109058 13-9-2-22

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3866

Dwg Rev: p22

Prog Rev: Lim

13-9-2-22

(16)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



13-9-2-22



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

50960123 (16)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1/2-1 deburr

2- form as per dwg D3866

SB 09/03/20 (16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 45580

Part Number: D38663

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/03/30 (16)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 09/03/30 (16)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-30 (16)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST139A

AS 09/03/31 (16)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/01 (16)

Job Completion



MF 09-03-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 45580
Description: PLATE		Part Number: D3866-3
Inspection Dwg: D3866-3, Rev: PRE LHM		Page 1 of 1

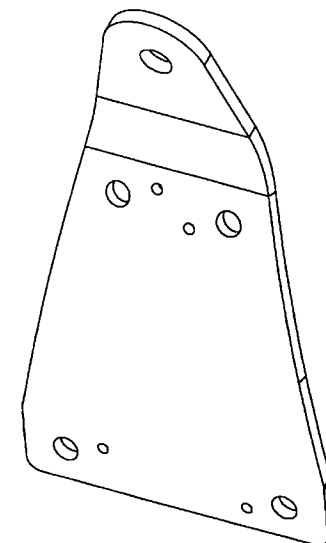
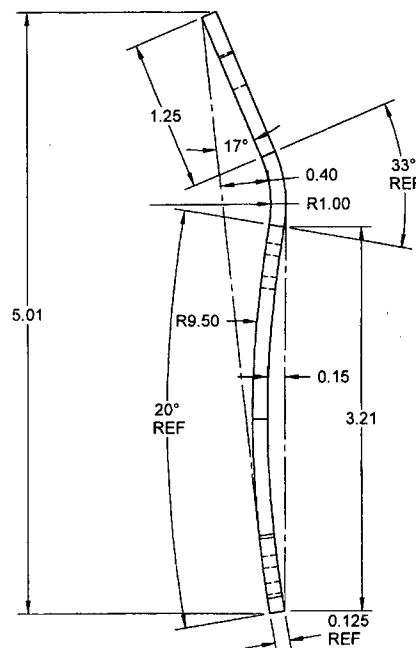
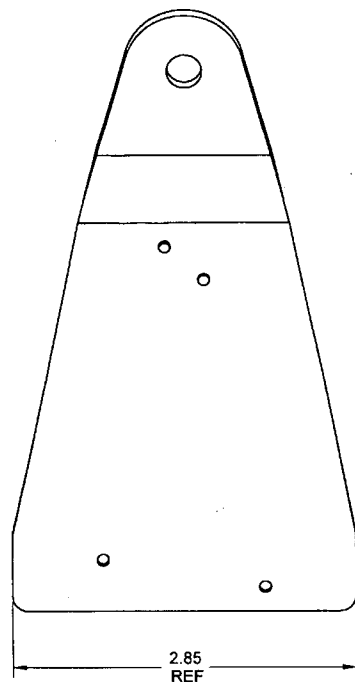
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .098	+ .004 - .001	.100	X			
Ø .295	+ .006 - .001	.296	X			
2.85	± .030	2.852	X			
5.10	± .030	5.103	X			
.750	± .010	.751	X			
1.257	± .010	1.256	X			
.325	± .010	.325	X			
1.345	± .010	1.341	X			
.204	± .010	.200	X			
.224	± .010	.225	X			
2.770	± .010	2.772	X			
.274	± .010	.274	X			
4.601	± .010	4.605	X			
1.423	± .010	1.427	X			
.125	± .010	.124	X			

Measured by: IB	Audited by: S	Prototype Approval: N
Date: 9-2-23	Date: 09/02/23	Date: A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3866-3 PLATE
MADE FROM D3866-3F

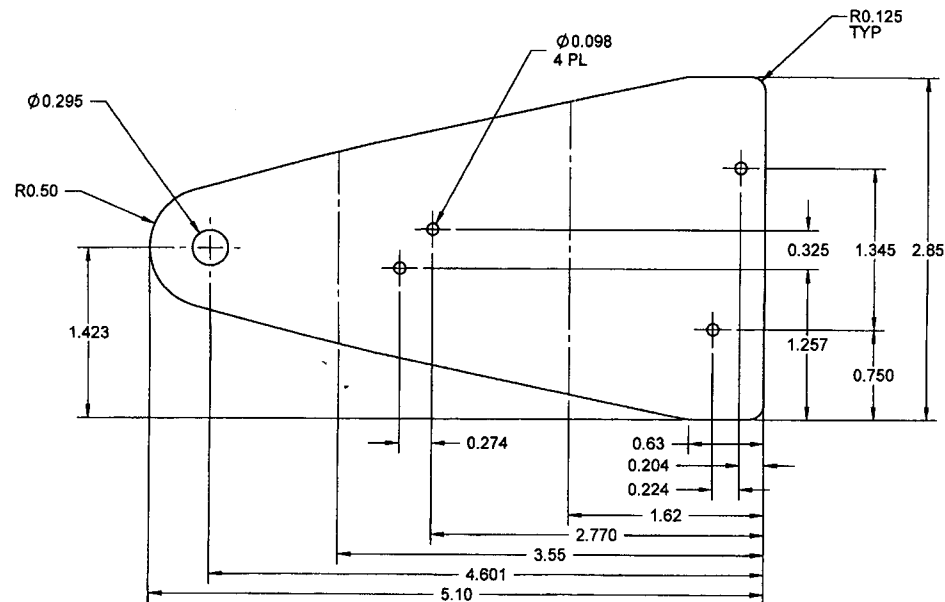
RELEASED
09/01/13

45580

NOTES:

- 1) MATERIAL: MADE FROM D3866-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.12 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3866	SHEET 5 OF 6
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	NTS
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D3866-3F PLATE FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.125 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
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#4558C
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9/4/13 MP